

# Work Order ID 56283

February 17, 2010 2:23:13 PM



Page 1

Item ID: D1048

Accept



Setup Start



Revision ID:

Item Name: Saddle

Stop



Start Date: 2/17/10

Start Qty: 12.00



Cust Item ID:

Required Date: 2/24/10

Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

*RT*

Date: 10-2-17

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D1048

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D1048

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

*304 . 063*

*IB 10-2-22*

*9/10/02/23 (20) (21)*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*IB 10-2-22*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*8/10/02/23*

*count (21)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item Name: Saddle

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Cust Item ID:

Required Date: 2/24/10

Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

I-Deburr if required. Break all sharp corners .010 / .020 as per dwg.

N/A

140



Brake NC

NC BRAKE

0.00

Memo

0.00

Form as per dwg D2010 using DT8053

2/20/09 (21)

150



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

5.06/07

counter (x21)

Quality Control



W/O:		WORK ORDER CHANGES					
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# Work Order ID 56283

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Item ID: D1048

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Setup Start



Revision ID:

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Item Name: Saddle

Start Date: 2/17/10

Start Qty: 12.00



Cust Item ID:

Required Date: 2/24/10

Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

START TIME:

10:30 AM

OVEN TEMPERATURE:

320°F

FINISH TIME:

11:00 AM

Powder Coating

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location:

2

0.00



Packaging

Memo

0.00

Packaging

(24) 0

(21) 0

10-3-11 sl (210)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Item Name: Saddle

Start Date: 2/17/10

Start Qty: 12.00



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Required Date: 2/24/10

Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/03/10

MF

10-3-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries



# Picklist Print

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Page 1

Work Order ID: 56283



Parent Item: D1048



Parent Item Name: Saddle

Start Date: 2/17/10

Required Date: 2/24/10

Comments: IPP: B 02.02.22 Re-format NG  
IPP Rev:C Now on Waterjet 06-12-06 JLM

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	191.8899	0.2274	.4		



304/316 Sheet .063



B 10-2-22

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
MAT	191.8898737	
106860	8.0295	
111924	25.1689737	
112442	29.8865	
113295	128.8049	

113295

21

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 54283  
B810-217

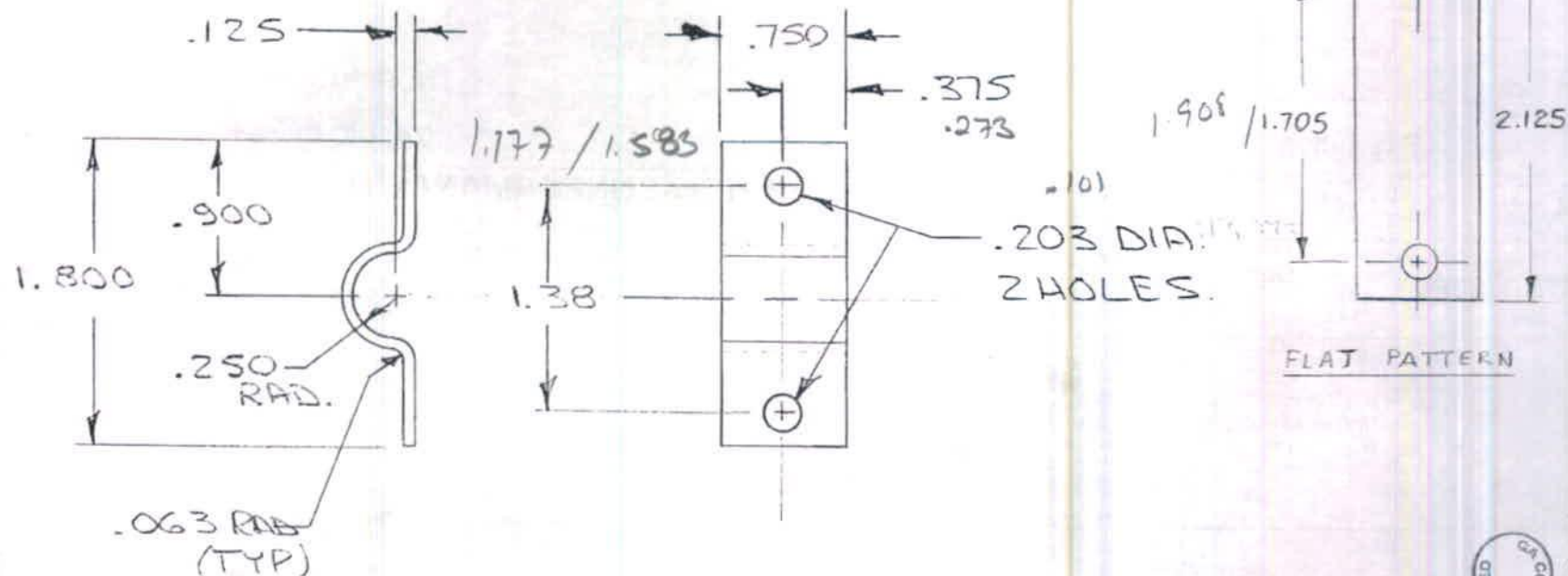
# NOTES:

## 1) MATERIAL

STAINLESS STEEL  
T304#2B .062 THICK

2) FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7)  
PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.010 TO 0.020



D1048



A	REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER NAS S23		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR	
	RF		DRAWN	BASIC CODE	DM DASH NO.	CONTRACT NO.				
			APPROVED	D-DIMPLE	IN-HEAD NEAR SIDE	DESIGN	CRANLEY	DATE	5/17/77	
			DESCRIPTION OF CHANGE	C-COUNTERSINK	IN-HEAD FAR SIDE	DESIGN	CRANLEY	DATE	5/17/77	
REQUIREMENTS - UNLESS OTHERWISE SPECIFIED		BASIC CODES		TITLE		CLAMP				
GENERAL		LIMITS		CODE		D1048				
1. DIMENSIONS ARE IN INCHES		1. TOLERANCES - .XX ± .030		DWG. NO.		1:1				
2. SURFACE ROUGHNESS 125		2. ANGLES 30° ± 10°		SCALE		1:1				
3. REMOVE SHARP EDGES .015 MAX.		3. PARALLELISM ± .0025		SHEET		1 OF 1				
4. THREADS PER INCH - 5 - 7742		4. ECCENTRICITY .005 MAX.		REV		A				
5. HOLES PER AND 10387		5. SYMMETRY ABOUT ALL M/C CENTER LINES .005		REPORT ALL DISCREPANCIES - DO NOT SCALE						

01.12.05  
ADD FLAT PATTERN

2

1

1

W/O:		WORK ORDER CHANGES					
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